

Date: Monday, 07/04/2008 11:47:18 AM  
 User: Julie Lecocq

## Process Sheet

0205-564-041

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: WEARPLATE
<b>Job Number</b>	: 38432		
<b>Estimate Number</b>	: 12403		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D3511041
<b>This Issue</b>	: 07/04/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D3511 REV A
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 38267	<b>Drawing Revision</b>	: A
	<b>Type</b>	<b>Material</b>	:
	: SMALL /MED FAB	<b>Due Date</b>	: 30/04/2008
<b>Written By</b>	:	<b>Qty:</b>	6 Um: Each
<b>Checked &amp; Approved By</b>	: <u>JD 08.4.06</u>		
<b>Comment</b>	: Est Rev:A New Issue 06-05-04 JLM		
	: Est Rev:B New process 06-05-05 EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S188	304 SHEET .188" THICK
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**Comment:** Qty.: 1.5572 sf(s)/Unit Total : 9.3429 sf(s)  
 304 SHEET .188" THICK  
 (M304S0188)  
 Batch: 107676 IB 8-4-10

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3511  
 Dwg Rev: A IB 8-4-10  
 Prog Rev: A  
 2-Deburr if necessary  
 Identify as D3511-1 IB 8-4-10

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

5 08/04/10 (+7)

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Job Number: 38432

Part Number: D3511041

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 D35031 CUP



Comment: Qty.: 8.0000 Each(s)/Unit Total: 48.0000 Each(s)

CUP

Batch:

*335670=2 328277=4 338283=40 208.04.11 7*

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bend fwd 90 deg. bend per dwg D3511

*SB 08/04/11*

*7*

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*SB 08/04/11 (7)*

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3511

A/R SS ROD Batch: *M106162*

*SB 08.04.16*

*7*

9.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D3511

*SB 08/04/16*

*7*

10.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*SB 08-04-16*

*7*

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*SB 08.04.16*

*7*

12.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

*M 100700*

*SB 08-04-2*

*30 min.*

*23/04/2008*

*S.095*

*#1 319.0*

*#3 351.0*

*#3 38432*

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



70

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 08/09/23

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

238A

08/09/23 7

15.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/24

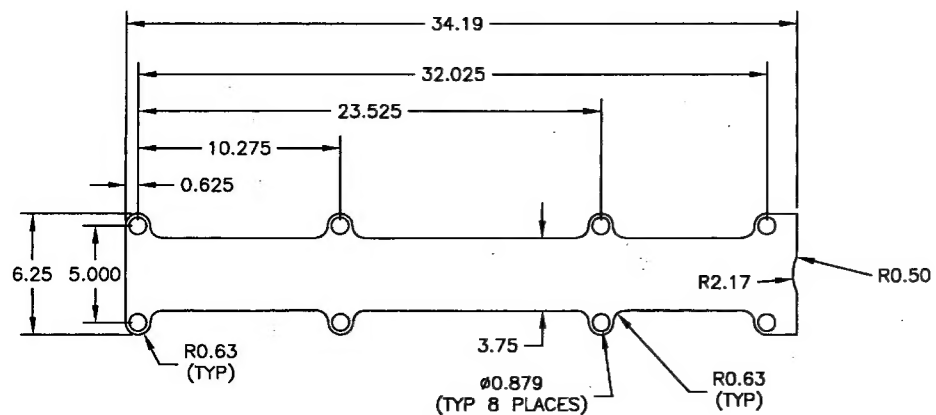
Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



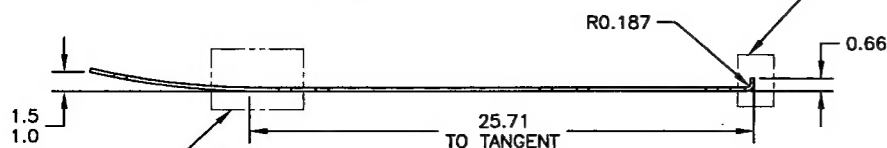
u 08.04.24





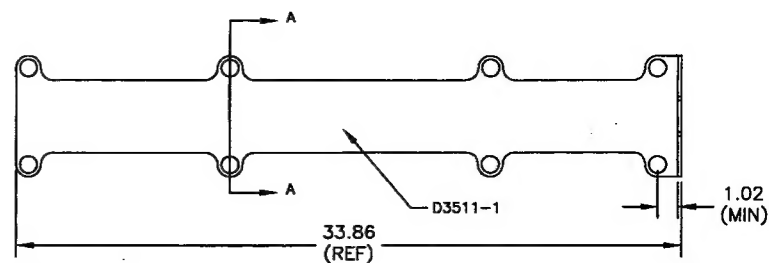
**D3511-1F FLAT PATTERN**

NOTE: BEND BEFORE WELDING



**D3511-1 BEND DETAIL**

NOTE: BEND AFTER WELDING



**SECTION A-A**

**D3511-041 WELD DETAIL**

**D3511-041 WEARPLATE ASSEMBLY**

- 1) MAKE D3511-1F WEARPLATE FROM: AISI 304/316 STAINLESS STEEL (0.188 THICK)  
(REF DART MATERIAL SPEC. M304S7GA)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ASSEMBLY BLACK SANDEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3511-041 WEARPLATE ASSEMBLY PARTS LIST**

QTY -041	PART NUMBER	DESCRIPTION
X	D3511-041	WEARPLATE ASSEMBLY
1	D3511-1	WEARPLATE
8	D3503-1	CUP

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 55432

RELEASED

06 04 25

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A	06.04.04	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	J.H.	APPROVED
DATE	06.04.04	TITLE
		WEARPLATE
		SCALE
		NTS

**DART**

**DART AEROSPACE LTD.**  
WARRICKSURY, OXFORD, CANADA

DRAWING NO.  
D3511

REV. A  
SHEET 1 OF 1